

SMALL FAB

[Dart Hawkesbury] Job Sheet - David, Logan

7789

9-12



Dart Aerospace Ltd
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Canada

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RBT18603
Job Sheet 180393



5896

Part No: RBT18603**Job Qty:** 1 ea**Part Name:** Tail Rotor Feathering Bearing Removal Tool**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 7/5/18**Job Tracking No:****Due Date:** 9/7/18**Created By:** Logan David**Type:** SOLD**Description:****Note:** RBT18603 REV:H IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/7/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	1 pcs		9/7/18	0.00	0.25	Small Fab-3		MLL DAS
120	QC	1 pcs		9/7/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		9/7/18	0.00	0.00	Packaging3-1		MLL 9-89
140	QC21-SA	1 Ea		9/7/18	0.00	0.00	QC21		MLL 18.10.12.

Part Op
Descriptions: 110 - 1-Assemble as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90692A723	Spring Pin	1 pcs (1 ea)	90-Start up Operation	5044109
NTA-815	Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5036193
RBT18603-1	Handle	1 Ea (1 ea)	110-Small Fab	5115573
RBT18603-3	Modified Rod	1 Ea (1 ea)	110-Small Fab	5115356
RBT18603-5	Cup	1 Ea (1 ea)	110-Small Fab	5115147
RBT18603-7	Foot	1 Ea (1 ea)	110-Small Fab	5085898
TRC-815	Needle Bearing Washer	2 Ea (2 ea)	110-Small Fab	5088953

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90692A723	1	246	0
110-Small Fab	NTA-815	1	18	0
	RBT18603-1	1	1	0
	RBT18603-3	1	0	0
	RBT18603-5	1	0	0
	RBT18603-7	1	0	0
	TRC-815	2	28	0

Part Specifications

Specifications could not be found.

Plex 8/1/18 9:01 AM dart.logan.david



Container No: S117685



Part: RBT18603

Job No: 180393

Serial No/Batch: S117685

Revision: H

Inspector:

Exp Date:

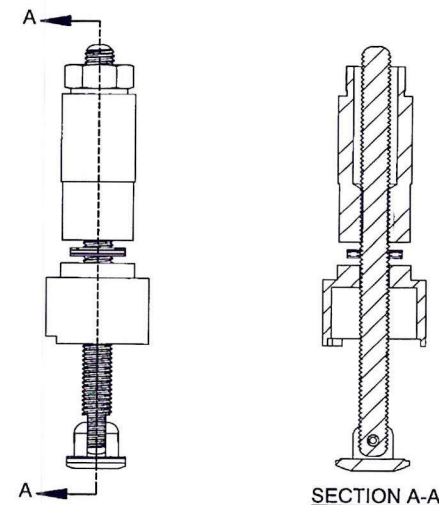
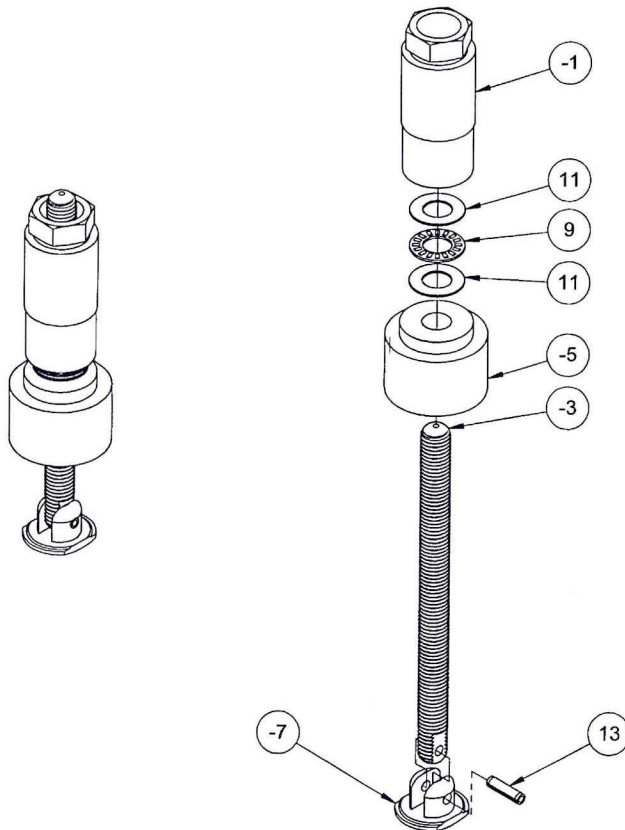
Instructions:

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Hawkesbury, ON K64 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/12/18

ITEM #	QTY	PART #	TITLE
-1	1	RBT18603-1	HANDLE
-3	1	RBT18603-3	MODIFIED ROD
-5	1	RBT18603-5	CUP
-7	1	RBT18603-7	FOOT
9	1	TORRINGTON #NTA-815	THRUST NEEDLE ROLLER BEARING
11	2	TORRINGTON #TRC-815	NEEDLE BEARING WASHER
13	1	McMaster#90692A723	SPRING PIN 3/16" x 3/4" LG.

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	HOLE ON DRAW BOLT ENLARGED TO ALLOW PROPER SWIVELING OF FOOT	-	6/1/2001	-	-
2	CHANGED CHAMFER TO FLAT RECESS, AND ADDED 274° CUT OUT TO -5 CUP	-	7/13/06	-	-
3	RECESSED -7 LIP .03 DEEP x 1.12	-	7/17/06	-	-
4	DELETED HOLE IN TOP OF -3 DRAW BOLT AND CHANGED -3 BOTTOM HOLE FROM .199 DIA., CHANGED -7 FOOT HOLE FROM .188 DIA CHANGED TO NEW REV. LOG, TITLE BLOCK, & BOM. ALSO ADDED ASSEMBLY VIEW	-	1/28/08	WP	DW
5	CHANGED -3 MATERIAL TO B7, DIM .22 TO .270 AND DIM .25 TO .300 ALSO CHANGED -5 DIM .63 DIA. TO .75 DIA. AND DIM .28 TO .312	-	12/18/08	WP	DW
6	-5 ADDED ENGRAVE T/N, S/N, "MADE IN USA", CH'D -1 & -5 TO YELLOW ZINC	-	5/18/09	RJC	RW
6A	DELETED NOTE, ADDED P/N FOR -3 PER R.W	-	3/15/12	RJC	RW
7	BROKE OUT INTO INDIVIDUAL SHEETS, -1 CH'D DIM WAS DRILL .72 DIA x 2 DEEP IS .75 DIA. x 2 DEEP	-	6/26/13	BIM	GE
H	ITEM 13 PURCHASE INFORMATION ADDED, TEMPLATE UPDATED, ITEM 11 BEARING WASHER CHANGED FROM #TRA-815 TO TRC-815, ITEM -3 NAME CHANGED FOR MODIFIED ROD	17-811	18.1.8	VM	ML



SECTION A-A

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) SPEC: N/A
 5) BREAK ALL SHARP EDGES: N/A
 6) IDENTIFICATION: N/A

RBT18603 TAIL ROTOR FEATHERING BEARING REMOVAL TOOL

DART AEROSPACE Howesbury, Ontario, Canada	
TITLE TAIL ROTOR FEATHERING BEARING REMOVAL TOOL	
PART NO. RBT18603	REV H
TOOL NO. RBT18603	
INITIALS AND DATE	
DESIGNED BY: VM 1/8/2018	TOLERANCES: XXX ± .005 FRACTIONS ± 1/8
DRAWN BY: VM 01/08/2018	XX ± .01 ANGLES ± .5°
CHECKED BY: VM 01/08/2018	X ± .1 SURFACE 125
MFG REVIEW BY: DD 01/08/2018	APPROVED BY: ML 01/09/2018
SCALE: NTS	SHEET 1 OF 5
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